

Amendments to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A method for the manufacture of a cam shaft from a tube having non cam regions, and cam regions formed on the tube at positions where bearer rings are attached thereto, the method comprising the following steps:

placing bearer rings, produced in a separate method and in correspondence with prospective locations of cam regions on said cam shaft, in a high internal pressure forming tool together with the tube to be formed, whereby the bearer rings are attached by expansion of the tube in a frictional and interlocking manner, each of the bearer rings having an outer surface and an inner surface, and wherein the bearer rings possess the same wall thickness;

closing the forming tool axially, subjecting the tube to a predetermined axial force and a medium under high internal pressure so that the tube expands to form said cam regions, wherein the diameter of the tube in said cam region are greater than the diameter of the tube at the non cam regions; and

in a first method step prior to said high internal pressure forming, regions of the tube which are clear of the regions in which the cams are seated are so kneaded and/or upset such that said tube regions which are clear of the cam regions are increased in thickness and/or are stretched so that bearing faces, drive and/or control elements are formed from the tube itself, whereby the shaft has all cams in form and in position on a single piece.

Claims 2 (canceled)

Claim 3 (previously presented): The method as set forth in claim 1, characterized in that between the cam shaft ends in a step prior to internal high pressure forming bearing faces and the eventual region where the cams are to be seated, are produced by round kneading and by reducing the diameter in this part to the desired size.

Claim 4 (previously presented) The method as set forth in claim 1 characterized in that bearing faces are produced between the cams by internal high pressure forming by expanding the tube.

Claim 5 (previously presented): The method as set forth in claim 1, characterized in that the bearer rings are hardened in a known manner prior to being placed in the internal high pressure forming tool.

Claims 6 - 18 (canceled)

Claim 19 (canceled)